

Date: Thursday, 2/14/2008 10:56:35 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	37424					
Estimate Number	10940					
P.O. Number				Part Number	D29381	
This Issue	2/14/2008	S.O. No.*		Drawing Number	D2938 REV C	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /	Type	MACHINED PARTS	Drawing Revision	C	
Previous Run	34631			Material		
Written By	<i>JL</i> 080214			Due Date	3/8/2008	Qty: 10 Um: Each
Checked & Approved By						
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC					
	Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	
		Batch No: <u>B34873</u>	<i>QF 08/04/06</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	<i>QF 08/04/06</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>QF 08/04/06</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>QF 08/04/06</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37424
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.131	.131	.127	.128		
B	0.100	0.140		.134	.130	.138	.130		
C	0.100	0.140		.122	.121	.117	.117		
D	0.210	0.230		.217	.218	.219	.220		
E	1.245	1.255		1.248	1.248	1.248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1.248		
G	2.495	2.505		2.499	2.500	2.499	2.500		
H	0.510	0.515		.511	.511	.510	.510		
I	1.572	1.582		1.577	1.577	1.579	1.579		
J	2.495	2.505		2.500	2.500	2.501	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.118	.117	.118	.119		
O	0.540	0.560		.545	.555	.553	.555		
P	0.490	0.510		.504	.510	.502	.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.741	2.741	2.743	2.742		
S	0.240	0.270		.252	.244	.250	.248		
T	0.100	0.180		.133	.128	.146	.140		
U	1.625	1.635		1.630	1.630	1.632	1.630		
V	1.362	1.372		1.370	1.370	1.369	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.260	1.261		
Y	1.565	1.585		1.569	1.570	1.570	1.568		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>8T</i>	Audited by:	<i>J.L.</i>
Date:	<i>08/04/06</i>	Date:	<i>08/04/07</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>JLM</i>

DART AEROSPACE LTD	Work Order:	37424
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 1/4	6 3/8	7 3/8	8 1/4	By	Date
A	0.100	0.140		.128	.128	.128	.127		
B	0.100	0.140		.129	.129	.129	.128		
C	0.100	0.140		.121	.121	.121	.119		
D	0.210	0.230		.220	.218	.224	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.501	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.238	.237		
N	0.100	0.140		.117	.118	.118	.117		
O	0.540	0.560		.550	.550	.554	.556		
P	0.490	0.510		.505	.505	.503	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.743	2.743	2.743	2.743		
S	0.240	0.270		.248	.248	.250	.246		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.633	1.633	1.633	1.633		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.260	1.261		
Y	1.565	1.585		1.570	1.570	1.570	1.569		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	8/15	Audited by:	J.L.
Date:	08/03/06	Date:	08/04/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JL

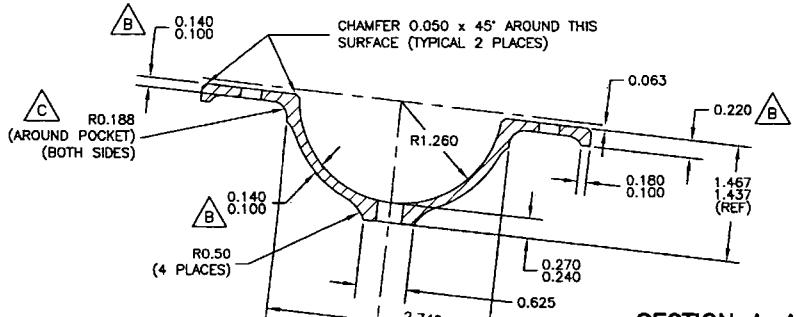
DART AEROSPACE LTD	Work Order:	37424
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

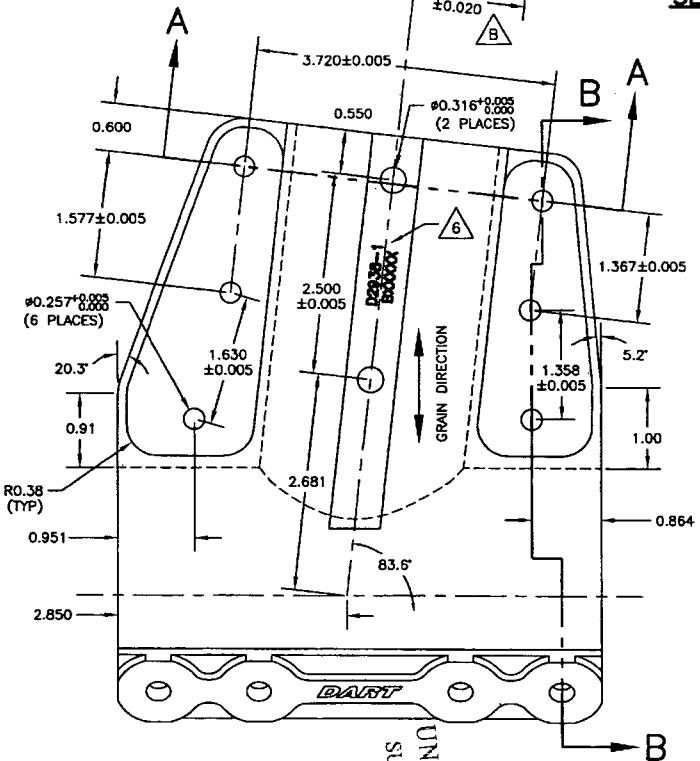
				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	9*	10*	3	4	By	Date	
A	0.100	0.140		.128	.128					
B	0.100	0.140		.129	.129					
C	0.100	0.140		.121	.121					
D	0.210	0.230		.221	.221					
E	1.245	1.255		1.250	1.250					
F	1.245	1.255		1.250	1.250					
G	2.495	2.505		2.500	2.500					
H	0.510	0.515		.510	.510					
I	1.572	1.582		1.577	1.577					
J	2.495	2.505		2.501	2.501					
K	0.257	0.262		.258	.258					
L	0.312	0.317		.316	.316					
M	0.235	0.240		.237	.237					
N	0.100	0.140		.117	.117					
O	0.540	0.560		.555	.550					
P	0.490	0.510		.501	.508					
Q	3.715	3.725		3.718	3.718					
R	2.720	2.760		2.743	2.743					
S	0.240	0.270		.246	.246					
T	0.100	0.180		.140	.140					
U	1.625	1.635		1.633	1.633					
V	1.362	1.372		1.370	1.370					
W	0.316	0.321		.321	.321					
X	1.250	1.270		1.260	1.260					
Y	1.565	1.585		1.569	1.569					
Z	0.178	0.198		.188	.188					
AA										
AB										
AC										
AD										
AE										
AF										
AG										
AH										
Accept/Reject										

Measured by:	<i>SP</i>	Audited by:	<i>JL</i>
Date:	08/04/07	Date:	08/04/07

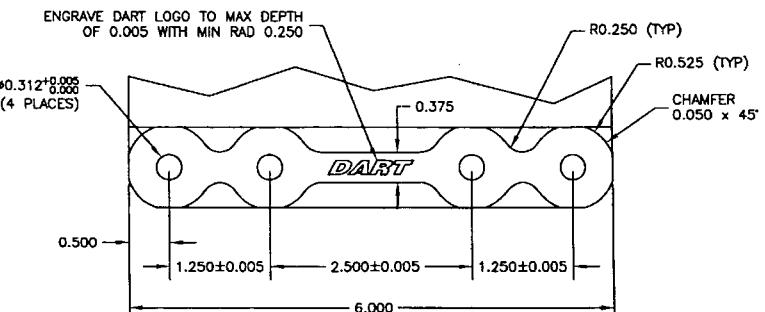
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>SP</i>	<i>JL</i>



SECTION A-A



SECTION B-B

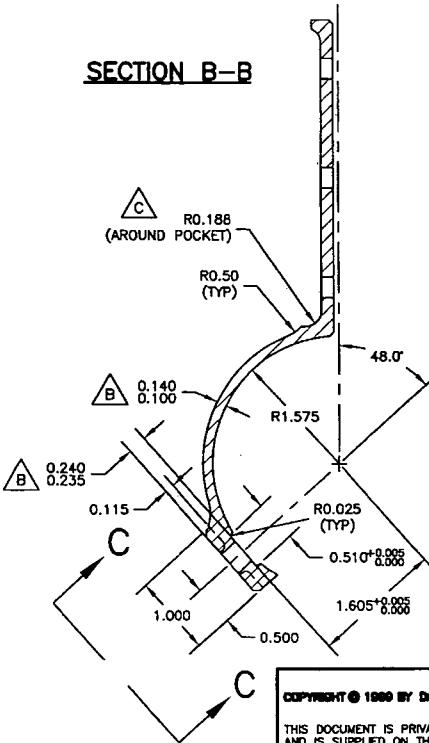


VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	06.11.09	R0.188 WAS R0.30 TO R0.25
CHECKED	APPROVED	00.05.29	CHANGED GEOMETRY AND MATERIAL
A		99.11.12	NEW ISSUE
WORK ORDER NO.	CB	DART	DART AEROSPACE USA, INC. BELLEVUE, WA
UNCONTROLLED COPY		DRAWING NO.	REV. C
ENGINEERING COPY		D2938	SHEET 1 OF 1
SUBJECT TO AMENDMENT		DATE	SCALE
WITHOUT NOTICE		06.11.09	2:3
NO. 37424		TITLE	SADDLE OUTSIDE